

Date: Thursday, 8/30/2007 3:51:02 PM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	LUG
Job Number	34357		
Estimate Number	10271		
P.O. Number	N/A	Part Number	D2561
This Issue	8/30/2007	S.O. No.	N/A
Prsht Rev.	NC	Drawing Number	D2561 REV B
First Issue	N/A	Project Number	N/A
Previous Run	32403	Drawing Revision	B
Written By		Material	N/A
Checked & Approved By	<u>HD</u> 07-08-31	Due Date	9/21/2007
Comment	Est C 00.05.19 Added inspect level 8 EC Est Rev:D Now on Waterjet 06-06-14 JLM	Qty:	56
		Um:	Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:	
1.0	M6061T6B0250X06000	6061-T6 Bar .25" x 6.0"	
		Comment: Qty.: 0.3850 f(s)/Unit Total : 19.2518 f(s) Material: 6061-T6, or 5052-H34 6.00" x 0.25" Thick Batch: <u>M100782-56</u> <u>HB 07-09-01</u>	<p><i>Scrap = 1</i> <i>Total = 57</i></p> <p>SAN 07/09/04</p>
2.0	WATER JET	FLOW WATER JET	
		Comment: FLOW WATER JET 1-Cut as per Dwg D2561 Dwg Rev: <u>B</u> <u>HB 07-09-01</u> Prog Rev: <u>B</u>	<p><i>PFO</i> </p>
		2-Deburr if necessary	<p>SAN 07/09/04</p> <p>56</p>
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	<p>SAN 07/09/04 07/09/04</p> <p>56</p>
4.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	<p><i>5</i> 07/09/04</p> <p><i>Count</i> <i>x56</i></p>
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
		Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr, no sharp edges	<p><i>Wm 07/09/06</i></p> <p><i>56</i></p>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 07/09/04
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/09/04	2.0	One part scrap, tab on part was cut in side the part instead of cutting out side.	J 07/09/04	Scrap, destroy - replace fix prog	SAD 07/09/04	✓ 07/09/04	✓ 07/09/04	✓ 07/09/04

NOTE: Date & initial all entries

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Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: WA1

16 02-09-10

56

7.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

D 02-09-11

Job Completion



U 02-09-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	34351
Description: Lug Plate	Part Number:	D2561
Inspection Dwg: D2561	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

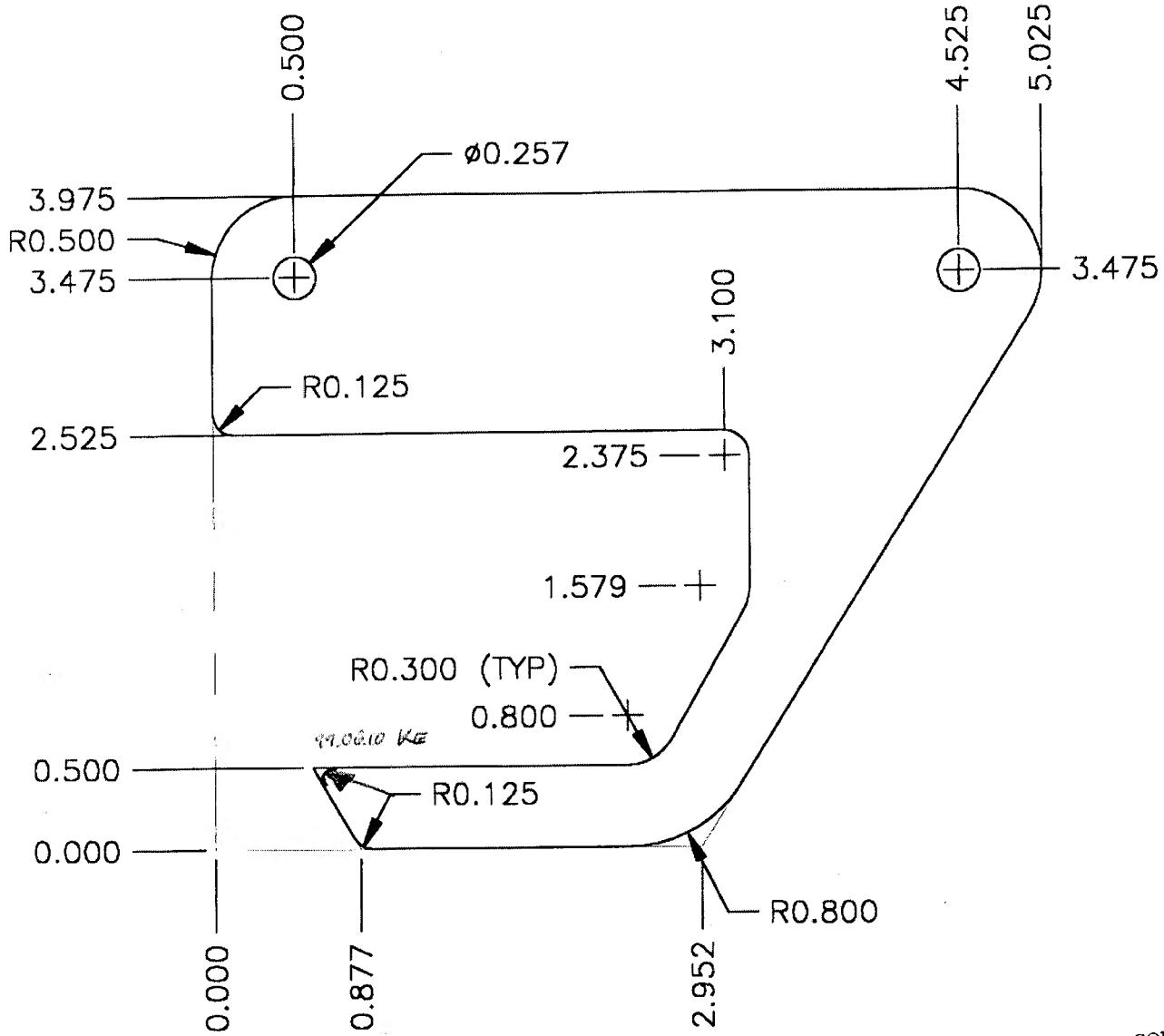
Measured by:	SAD	Audited by:	EN	Prototype Approval:	N/A
Date:	07/09/04	Date:	07/09/04	Date:	

Rev	Date	Change	Revised by	Approved
A	04.01.21	New Issue	KJ/RF	TT



DESIGN B. WILLIAMS	DRAWN BY B. WILLIAMS	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA
CHECKED <i>BW</i>	APPROVED <i>BW</i>	DRAWING NO. D2561
DATE 96.04.26		REV. B SHEET 1 OF 1 TITLE LUG PLATE SCALE 1:1

RELEASED
96 05 06



MATERIAL: 6061-T6 0.25 THICK
OR 6063-T6 0.25 THICK
OR 5052-H34 0.25 THICK

SHOP COPY
RETURN TO
ENGINEERING
INCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *34357*

